

Work Order ID 71086

Wednesday, June 22, 2011 8:46:50 AM



Page 1

Item ID:	D212-664-101TRN	Accept		Setup	Start	
Revision ID:	U/R				Stop	
Item Name:	Crosstube Turning Detail					
Start Date:	6/22/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	7/6/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>MF</u>	Date:	<u>11-06-22</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D212-664-141	Rev D <u>UR</u> <u>OK</u> <u>11.06.22</u>								

100		MORI SEIKI CNC LATHE LARGE	0.00	
Mori Seiki		Memo	0.00	<u>1</u> <u>OK</u>
Mori Seiki CNC Lathe Large		1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA113		
		2-Turn first side as per Folio FA113		
		3-Blend transition lines only, **do not sand whole tube**		
		*Use mill bastard file, brush file repeatedly with file card.		
		*Do not use sandpaper coarser than 320 grit.		<u>MM</u> <u>11/07/05</u>

110		QC1- Inspect dimensions to dimension sheet	0.00	
QC		Memo	0.00	<u>OK</u> <u>11/07/04</u>
Quality Control				<u>1</u> <u>OK</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71086

Wednesday, June 22, 2011 8:46:50 AM



Page 2

Item ID: D212-664-101TRN

Accept



Setup Start



Revision ID: U/R

Stop



Item Name: Crosstube Turning Detail

Start Date: 6/22/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/6/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 Mori Seiki	MORI SEIKI CNC LATHE LARGE	0.00							
Mori Seiki CNC Lathe Large	Memo 1-Turn second side as per Folio FA113 2-Blend transition lines only, **do not sand whole tube**: *Use mill bastard file, brush file repeatedly with file card. *Do not use sandpaper coarser than 320 grit. 3-Remove sand and plugs	0.00		11/07/05 mm-l		1	0		
130 QC	QC1- Inspect dimensions to dimension sheet	0.00							
Quality Control	Memo	0.00		ent 11/07/06		1	0		
140 QC	QC8- Inspect parts - second check	0.00							
Quality Control	Memo	0.00		B.A 11/07/06		1	0		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID 71086

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Page 3

Item ID: D212-664-101TRN

Accept



Setup Start



Revision ID: U/R

Stop



Item Name: Crosstube Turning Detail

Start Date: 6/22/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/6/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



HandFXtube

Crosstubes Chemical Conversion

0.00

DP

11-7-6

Memo

0.00

Hand Finishing Crosstubes

160



QC

QC3- Inspect Part Finish

0.00

1

Q

BE 11/07/07

Memo

0.00

Quality Control

170



Packaging

Packaging

0.00

DP

11-7-7

Memo

0.00

Packaging

Identify and Stock in kanban rack
Location: 46

W/O:		WORK ORDER CHANGES					
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Page 4

Item ID: D212-664-101TRN

Accept

Setup Start

Revision ID: U/R

Item Name: Crosstube Turning Detail

Stop

Start Date: 6/22/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 7/6/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/11
ME
11-07-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

Wednesday, June 22, 2011 8:46:47 AM

Page 1

Work Order ID: 71086



Parent Item: D212-664-101TRN



Parent Item Name: Crosstube Turning Detail


Start Date: 6/22/2011

Required Date: 7/6/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-03-06 new issue DD verified by:ec
IPP Rev B 08.04.02 removed Polish EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6005-128 		Manufactured	No			120	Each	0.0000	1	1			

Crosstube Material

D6005-180

B59307

1 mm.c 11/07/04

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 71086
Description: Crosstube Assembly (205/212/412 High Fwd)	Part Number: D212-664-141
Inspection Dwg: D212-664-141 Rev: D	-Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	0.200	+/-0.010	205	✓	vern	JP-01
	R0.063	+/-0.010	.063	✓	RG	
	2.740	+0.005/-0.000	2.741	✓	mirr	CNC-001
	5.097	+/-0.030	5.095	✓	vern	JP-01
	2.304	+0.005/-0.000	2.309	✓	mirr	CNC-001
	2.340	+0.005/-0.000	2.345	✓	"	
	2.398	+0.005/-0.000	2.403	✓	"	
	2.448	+0.005/-0.000	2.453	✓	"	
	2.498	+0.005/-0.000	2.503	✓	"	
	2.549	+0.005/-0.000	2.553	✓	"	
	2.599	+0.005/-0.000	2.602	✓	"	
	2.671	+0.005/-0.000	2.675	✓	"	
	2.701	+0.005/-0.000	2.705	✓	"	
SIDE B	0.200	+/-0.010	205	✓	vern	JP-01
	R0.063	+/-0.010	.063	✓	RG	
	2.740	+0.005/-0.000	2.745	✓	mirr	CNC-001
	5.097	+/-0.030	5.100	✓	vern	JP-01
	2.304	+0.005/-0.000	2.309	✓	mirr	CNC-001
	2.340	+0.005/-0.000	2.345	✓	"	
	2.398	+0.005/-0.000	2.403	✓	"	
	2.448	+0.005/-0.000	2.453	✓	"	
	2.498	+0.005/-0.000	2.503	✓	"	
	2.549	+0.005/-0.000	2.554	✓	"	
	2.599	+0.005/-0.000	2.607	✓	"	
	2.671	+0.005/-0.000	2.676	✓	"	
	2.701	+0.005/-0.000	2.706	✓	"	
	126.514	+/-0.020	126.520	✓	tape	mm.0-02

Measured by: mm.v/2K	Audited by: B.A	Prototype Approval:	N/A
Date: 11/07/05	Date: 11/07/06	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue (P/O D412-664-101)	KJ/JLM	
B	06.03.15	Tolerance revised for 5.097 per Dwg Rev update	KJ/JLM	
C	07.05.28	Dwg Rev updated	KJ/JLM	
D	10.02.02	Dimension 126.514 was 126.51	KJ	

8 7 6 5 4 3 2 1



Item	Qty -141	Qty -141B	Part Number	Description
1	X		D212-664-141	CROSSTUBE ASSEMBLY (205/212/412 HIGH FWD)
2		X	D212-664-141B	CROSSTUBE ASSEMBLY (214 HIGH FWD)
3	1	1	D6005-128	CROSSTUBE
4	2	2	D2893-1	SUPPORT
5	4	4	D3595-063-450	RUBBER CUSHION
6	4	4	MS21920-25	CLAMP (OR MS21920-26)
7	A/R	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

#71086

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6005-128
FINISHED LENGTH = 126.514±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D212-664-XXX" AND BATCH NUMBER ON INSIDE OF CUFF
USING VIBRATING STYLUS
- 7) WEIGHT: D212-664-141 = 33.6 lbs (PER IIN-D212-664)
D212-664-141B = 33.6 lbs (PER IIN-D212-664)
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALLY. TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2893-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2893-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-25 CLAMPS (OR -26) WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE D2893-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE SUPPORT.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

UNDER REVIEW

11.06.19
FOR PRO-SEALING SUPPORT

DEO ATTACHED

RELEASED
2009-10-29

D	REFORMAT/REVISE GENERAL NOTES/PART LIST: REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS; ADD -141B (ZN B4-2, D4-2); REMOVED REF & ADD TOLERANCES (ZN B4-3, C6-3, C8-3 & B6-3); RELOCATED FLAG #6 PER PAR 08-046 (ZN A5-3); MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4	RF	09.09.30
C	REMOVE -851 ABRASION STRIP; ADD MAGNOBOND 6398, CUSHION, REVERSE CLAMPS	PH	07.03.08
B	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	PH	05.02.04
A	NEW ISSUE	PH	00.12.12
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	9	DRAWING NO.	REV. D
MFG. APPR.	10	D212-664-141	SHEET 1 OF 4
APPROVED	10	TITLE	SCALE
DE APPR.	10	XTUBE ASS'Y (205/212/412 HI FWD)	NTS
DATE	09.09.30	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

C

B

A

D

C

B

A

12 13 15
D2893-1 SUPPORT
MS21920-25 CLAMP, 2X
D3595-063-450 RUBBER CUSHION, 2X
2 PL

A4-2

A

A

14.00 (-141)
OR 13.75 (-141B)

D

#71086

D212-664-501
BENT TUBE

SYM

D212-664-141/-141B
ASSEMBLY DETAIL

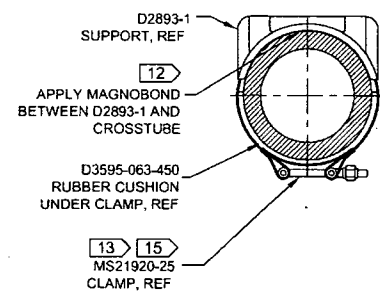
D

UNDER REVIEW

11.06.13

DEO ATTACHED

RELEASED
2009-10-29



SECTION A-A
SCALE 4X

D5-2

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	9	DRAWING NO.	REV. D
MFG. APPR.	DS	D212-664-141	SHEET 2 OF 4
APPROVED	14	TITLE	SCALE
DE APPR.	14	XTUBE ASS'Y (205/212/412 HI FWD)	NTS
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8 7 6 5 4 3 2 1

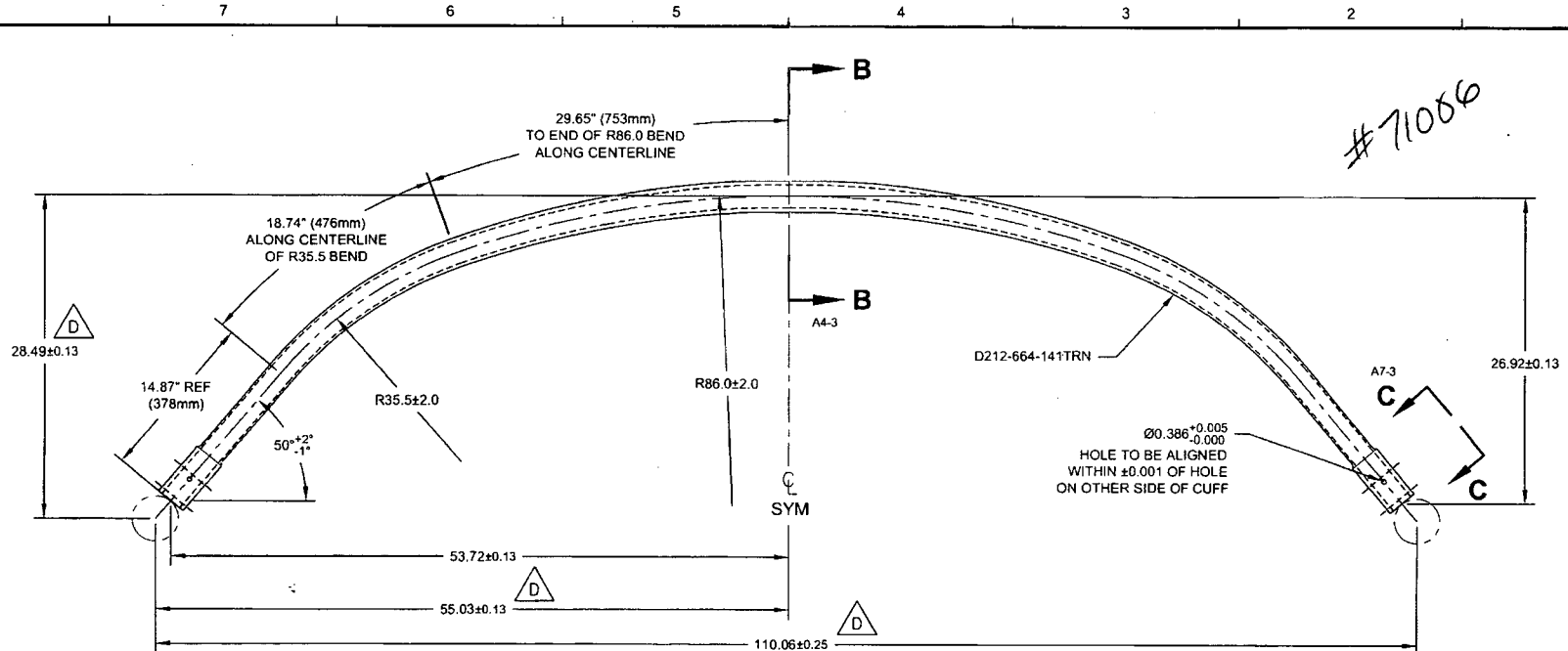
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

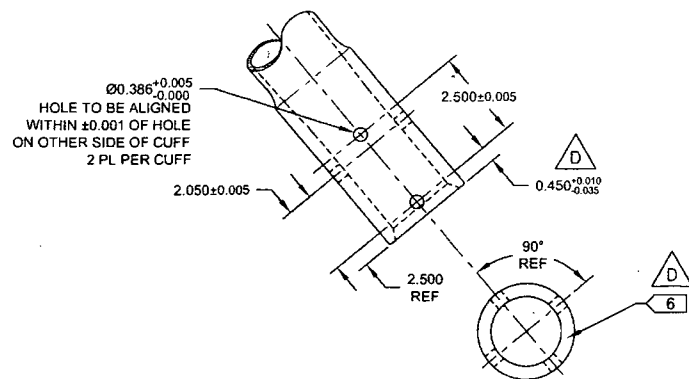
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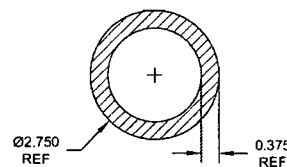


D212-664-501
BENDING AND DRILLING DETAIL

UNDER REVIEW



VIEW C-C: CUFF DETAIL
SCALE 3X



SECTION B-B
SCALE 4X

DEO ATTACHED

RELEASED
2009-10-29

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	Q	DRAWING NO.	REV. D
MFG. APPR.	DS	D212-664-141	SHEET 3 OF 4
APPROVED	AP	TITLE	SCALE
DE APPR.	W	XTUBE ASS'Y (205/212/412 HI FWD)	NTS
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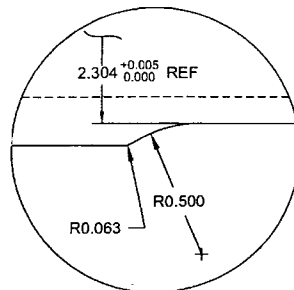
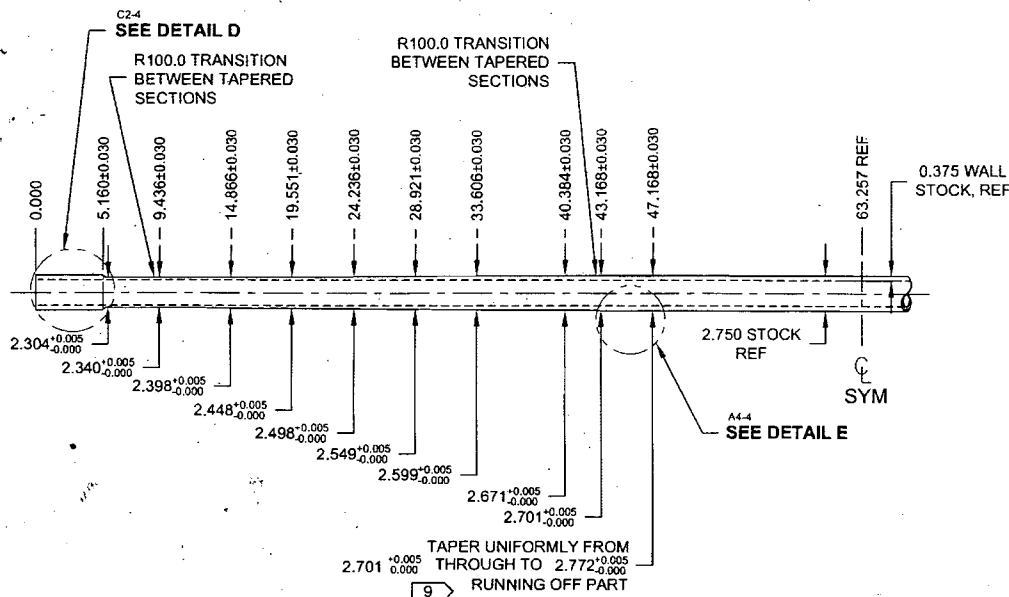
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

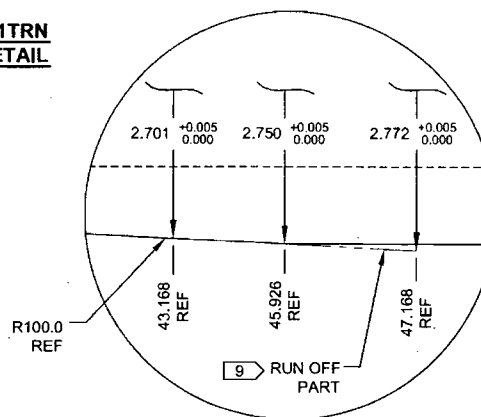
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D212-664-141TRN
TURNING DETAIL



UNDER REVIEW

DEO ATTACHED

RELEASED

2009-10-29

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	9	DRAWING NO.	REV. D
MFG. APPR.	15	D212-664-141	SHEET 4 OF 4
APPROVED	10	TITLE	SCALE
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DRAWING NO. D212-664-141	TITLE XTUBE ASSY (205/212/412 HI FWD)	REV. D	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D212-664-141-D-1	SHEET NO. SHEET 1 OF 2	SCALE NTS
DRAWN	CHECKED	OP	MFG. APPR.	ER	APPROVED	MP	DE APPR.
DATE 11.04.07	DATE 11.04.11		DATE 11.04.12		DATE 11/04/12		DATE 11.04.12

PURPOSE:

ADD AN INSPECTION WINDOW TO UNDERSIDE OF CROSSTUBE.

CHANGE:

NOTES 2 OF SHEET 1 IS AMENDED AS FOLLOWS:

IS:

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
MASK UNDERSIDE OF CROSSTUBE AS SHOWN (HATCHED AREA) AND
PAINT OUTSIDE PER DART QSI 005 4.2
REMOVE MASKING AND APPLY CLEAR COAT

WAS:

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2

RELEASED
2011-04-18

UNDER REVIEW

4/11.06.13

#71086

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

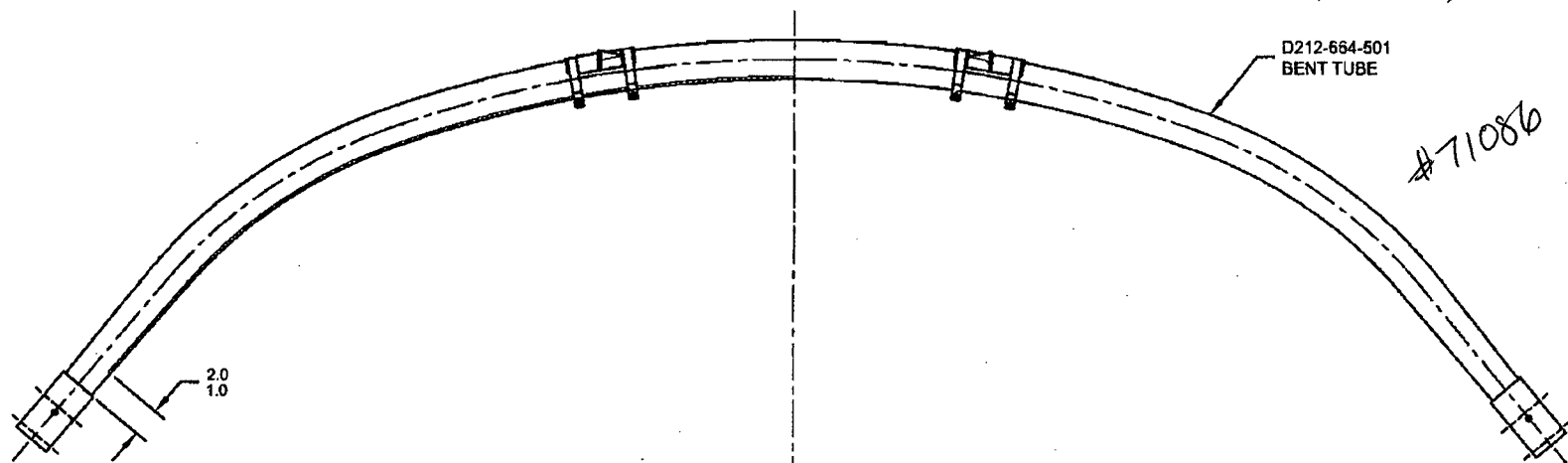
DRAWING NO. D212-664-141	TITLE XTUBE ASSY (205/212/412 HI FWD)	REV. D	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D212-664-141-D-1	SHEET NO. SHEET 2 OF 2	SCALE NTS
DRAWN	CHECKED	MFG. APPR.	APPROVED	DE APPR.		
DATE 11.04.07	DATE 11.04.11	DATE 11.04.12	DATE 11/04/12	DATE 11.04.12		

IS:

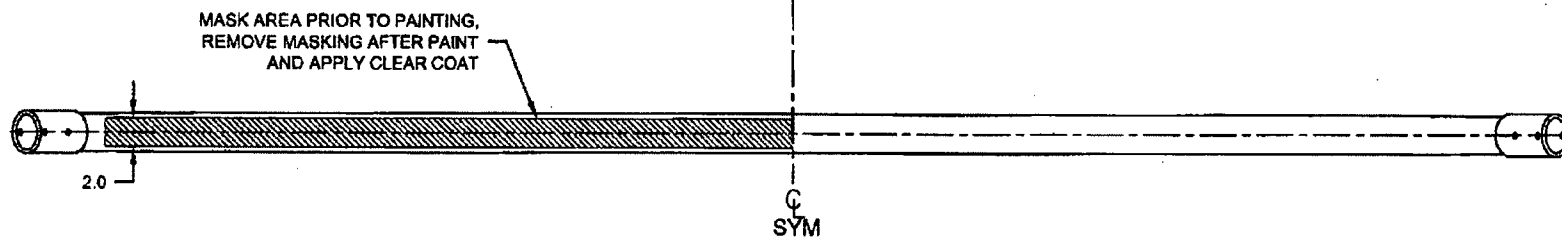
WAS:

UNDER REVIEW

11.06.13



**D212-664-141/-141B
ASSEMBLY DETAIL**



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries